

Work Order ID 67146

Wednesday, March 09, 2011 12:48:25 PM



Page 1

Item ID: D206-642-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D206-642

Rev N

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-311 CHG006

11-4-18

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67146

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Page 2

Item ID: D206-642-311

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube LH

Start Date: 3/9/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-311

Location: _____

PPP Rev: _____

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

Handwritten signature and date: 3/4/11

Handwritten date: 11/4/19
Handwritten initials: MF
Handwritten number: 11-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, March 09, 2011 12:48:30 PM

Work Order ID: 67146

Parent Item: D206-642-311

Parent Item Name: Skidtube LH






Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC
 IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
 IPP Rev:L 08-09-29 as per DSI9421 DD verified by:EC IPP Rev:M
 as per REV.N DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-341  Replacement Skidtube		Manufactured	No			110	Each	3.0000	1	1			
<div> <div>Location</div> <div>FG082</div> <div>36550</div> <div>44043</div> <div>44044</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>1</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
D206-648-013 CHG002  GHW Modification		Manufactured	No			110	Each	0.0000	1	1			
D2932-1  Saddle LH Out, 206		Manufactured	No			110	Each	0.0000	1	1			
D2933-1  Saddle LH In, 206		Manufactured	No			110	Each	0.0000	1	1			
D2938-1  Saddle LH Out, 206		Manufactured	No			110	Each	7.0000	1	1			

Location	Loc Qty	Loc Code
ST421	4	
66399	4	
ST428A	3	
66251	3	

67183
 67296
 67790
 67791
 66251

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 67146

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2939-1 Manufactured No

110 Each

0.0000

1



Saddle LH In, 206

AN3-41A Purchased No

110 Each

372.0000

8



Bolt

Location

Loc Qty

Loc Code

ST354

372

112431

1

114941

71

115936

100

116191

200

D2652 Manufactured No

110 Each

229.0000

16



Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

185

65049

64

66124

121

MS21042L3 Purchased No

110 Each

2,376.000

8



Nut

Location

Loc Qty

Loc Code

ST300

2376

116391

776

116540

800

116549

800

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 67146

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10

NAS1149D0363I

Purchased

No

110

Each

24.0000

8

8



Washer



11/16/13

[Signature]

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

18

105792

2

112279

16

AN5-10A

Purchased

No

110

Each

210.0000

4

4



Bolt



[Signature]

Location

Loc Qty

Loc Code

ST337

210

115589

50

115700

10

116704

50

116924

50

117010

50

AN5-11A

Purchased

No

110

Each

57.0000

4

4



Bolt



[Signature]

Location

Loc Qty

Loc Code

ST337

55

116419

25

116978

30

ST338

2

115422

2

116419 30

115422 10

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, March 09, 2011 12:48:31 PM

Work Order ID: 67146

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD516 NAS1149D0563J Purchased

No

110

Each

34.0000

8

8



Washer



M/16702 *lu*

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN4-6A

Purchased

No

110

Each

1,418.000

12

12



Bolt



lu

Location

Loc Qty

Loc Code

ST356

1418

112933

96

113149

17

115108

5

115936

200

116191

300

116400

400

116924

400

AN960JD416

NAS1149D0463J Purchased

No

110

Each

30.0000

25

25



Washer



M/17065 *lu* 11/4/18 ①

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 67146

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

4,376.000

12

12



Nut

Location

Loc Qty

Loc Code

ST300

4376

1123143

2

115589

10

115621

20

116188

2344

116823

2000

116188

D3407-043

Manufactured

No

110

Each

10.0000

1

1



Tow Ring

Location

Loc Qty

Loc Code

ST420

8

66386

8

ST464

2

50387

1

64071

1

67204

D3456-1

Manufactured

No

110

Each

61.0000

1

1



Washer

Location

Loc Qty

Loc Code

ST054

61

63239

2

64282

9

66848

50

66848

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Wednesday, March 09, 2011 12:48:32 PM

Work Order ID: 67146

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3457-1

Manufactured No

110 Each

25.0000

2

2



Washer

Location

Loc Qty

Loc Code

FG	10	
32409	10	
ST054	15	
45913	1	
66030	14	

MS21043-4

Purchased No

110 Each

823.0000

1

1



Nut

Location

Loc Qty

Loc Code

ST301	823	
114523	5	
114784	2	
116188	516	
116549	300	

AN4C5A

Purchased No

110 Each

434.0000

1

1



BOLT

Location

Loc Qty

Loc Code

ST346	434	
112243	434	

AN960C416

NAS1149C0463
R

Purchased No

110 Each

29.0000

1

1



washer

Location

Loc Qty

Loc Code

ST346	29	
100993	29	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, March 09, 2011 12:48:32 PM

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Work Order ID: 67146

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3413-1


Manufactured No

110 Each

35.0000

1

1

Ring

Location

Loc Qty

Loc Code

ST420

23

62961

9

66387

14

ST473

12

51586

1

53446

1

65294

10

D2712


Manufactured No

110 Each

568.0000

10

10

Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST012

250

66955

250

ST021

268

61331

18

65115

250

D2934


Manufactured No

110 Each

21.0000

2

2

Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

15

66043

15

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Wednesday, March 09, 2011 12:48:33 PM

Work Order ID: 67146



Parent Item: D206-642-311



Parent Item Name: Skidtube LH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

80.0000

2 2



Carlyle



Saddle Spacer

Location

Loc Qty

Loc Code

ST027

80

63558

9

66564

71

63558

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG ⁽¹⁾
2B			14			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: N

Date: 09.09.09

